

Work Order ID 122816

July-28-14 12:51:58 PM

*Blotch Sandpex*

\*122816\*

Page 1

Item ID: D4893-2

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Hard Point Adapter, RH

Start Date: 7/28/14

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 8/08/14

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4893

A

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank:3.375" long

2

Ø

MH

14/07/29

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FB193 and Dwg D4893

FOLIO REV: AA

DWG REV: H

DEBURR

2

Ø

MH 14/07/30

14/07/31

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Page 2

## Hand Finishing

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Page 3

**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/28/14      **Start Qty:** 2.00      **\*2\***

**Cust Item ID:**

Required Date: 8/08/14      Req'd Qty: 2.00      \*C\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

**DAS**  
**41**  
**9-89**

14-8-11

151

~~White Gloss~~(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*151\***

127892

0.00

Powdercoat

**Memorandum**

\$ 400

## Powder Coating

ATTN: BLACK SANDTEX

LOT 320

MASK AS PER NOTE 9

F 430

**DAS**  
**41**  
**9-89**

14-8-11

155

### QC3- Inspect Part Finish

0.00

**\*155\***

QC

## Memo

0.00

## Quality Control

**Work Order ID 122816**

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**\*122816\***

Page 4

Item ID: D4893-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Hard Point Adapter, RH  
Start Date: 7/28/14 Start Qty: 2.00 \*?  
Required Date: 8/08/14 Req'd Qty: 2.00 \*?  
Reference: Cust Item ID:  
Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
<b>*170*</b>									
Packaging	Memo	0.00				2x	DAS 28 9-89		AUG 12 2014
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-14

24-8-13

# Picklist Print

July-28-14 12:51:57 PM

Page 1

Work Order ID: 122816

\*122816\*

Parent Item: D4893-2

\*D4893-2\*

Parent Item Name: Hard Point Adapter, RH

Start Date: 7/28/14

Required Date: 8/08/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X05.00 0		Purchased	No				f	3.0750		1			

\*M6061T6B2 000X05 000\*

\*\*

6061T6 Bar 2.00 x 5.000

Location

Loc Qty

Loc Code

MAT007

3.075

m128980

3.075

m 126160

-6

M4

14/07/

\*

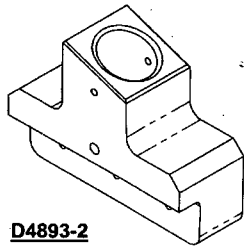
could not pull mat

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 122816
<b>Description:</b> Hardpoint Adapter, RH		<b>Part Number:</b> D4893-2
<b>Inspection Dwg:</b> D4893	<b>Rev:</b> A	<b>Page 1 of 1</b>

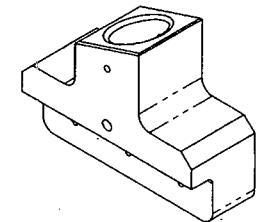
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
72°	+/-0.5°	72°	✓		MJP-04	vern
1.50	+/-0.030	1.504	✓		...	...
0.03 x 45°	+/-0.030 x +/-0.5°	0.030	✓		31006	Height gauge
2.45	+/-0.030	2.445	✓		MJP-04	vern
1.30	+/-0.030	1.295	✓		...	...
0.75	+/-0.030	0.740	✓		MJP-04	vern
2.500	+/-0.005	2.500	✓		...	...
1.250	+/-0.005	1.250	✓			
R0.25	+/-0.030	0.250	✓			
0.50	+/-0.030	0.495	✓			
Ø0.129	+0.005/-0.001	0.130	✓			
Ø0.204	+0.005/-0.001	0.205	✓			
1.50	+/-0.030	1.504	✓			
1.00	+/-0.030	0.995	✓			
1.00	+/-0.030	0.993	✓		MJP-08	vern
R0.13	+/-0.030	0.125	✓			Radius gauge
0.83	+/-0.030	0.830	✓		MJP-04	vern
0.10 x 45°	+/-0.030 x +/-0.5°	0.105 x 45°	✓		...	...
1.75	+/-0.030	1.750	✓			
1.46	+/-0.030	1.465	✓			
1.65	+/-0.030	1.648	✓			
4.00	+/-0.030	4.003	✓			
0.25 x 45°	+/-0.030 x +/-0.5°	0.250 x 45°	✓			
0.750	+/-0.010	0.750	✓		31006	Height gauge
Ø1.015	+0.002/-0.001	1.014	✓		MJP-04	vern
	+/-0.010					

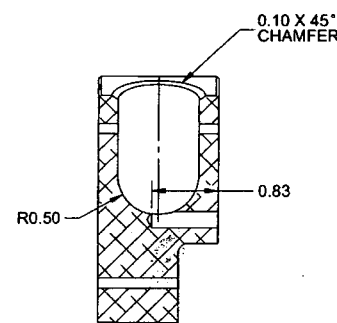
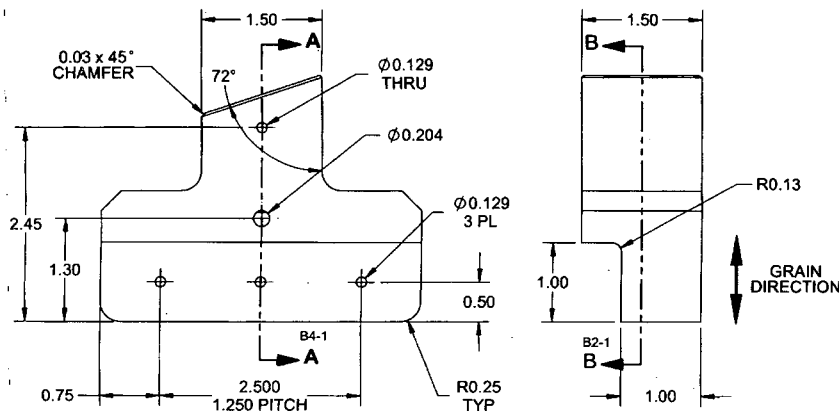
<b>Measured by:</b> [Signature]	<b>Audited by:</b> DAS 20 9-89	<b>Preliminary Approval:</b>
<b>Date:</b> 14/07/31	<b>Date:</b> 14-07-31	<b>Date:</b>
<b>Rev</b>	<b>Date</b>	<b>Change</b>
A	14.07.09	New Issue
<b>Revised by:</b> KJ		<b>Approved:</b> [Signature]



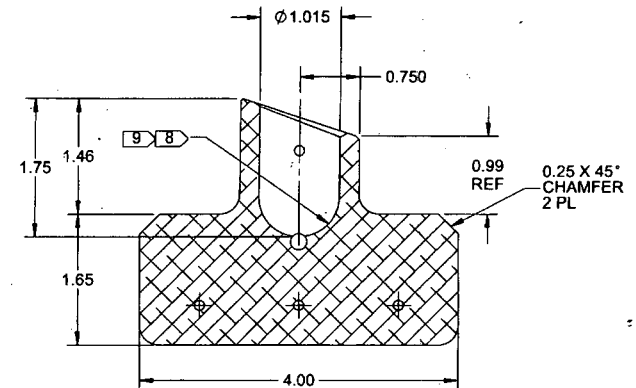
**D4893-2**



**D4893-1**



**SECTION A-A B7-1**



**SECTION B-B B6-1**

**D4893-1 HARDPOINT ADAPTER, LH  
D4893-2 HARDPOINT ADAPTER, RH OPPOSITE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.92 lbs
- 8) SURFACE FINISH 80-125 uin. IN THE BOTTOM OF THE Ø1.015 BORE IS ACCEPTABLE
- 9) MASK Ø1.015 BORING HOLE PRIOR TO POWDER COAT

*W/612286*

**RELEASED**  
2013-06-12  
*W*

A NEW ISSUE		RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>08</i>		
MFG. APPR.	<i>27</i>		
DE APPR.	<i>5</i>		
DATE	13.05.24		
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO. D4893	REV. A
		TITLE HARDPOINT ADAPTER	SHEET 1 OF 1
		SCALE NTS	
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